

Work Order ID 133131

Tuesday, May 26, 2015 12:47:44 PM

133131

Page 1

Item ID: D3368-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tail Rotor Pedal Lock

Start Date: 5/22/15 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/26/15 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJDate: MAY 27 2015

Tooling:

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2690	B2								
D3368	B								
D3384	C								

100

0.00

1000

Small Fab

Small Fab

Small Fab

Memo

0.03

1-Open D3373-7 lock package. Keep keys, lock body, lock body nut, screw, flat cam and lock barrel. Discard the rest.

2-Fabricate D3371-5 Cam Lock as per Dwg D3371

3- Cut cable to length as per dwg D2690 and D3384

4- Assemble lanyard to cyclic sock as per Dwg D3384
Identify as D3384-047

Identify as D3371-53-Assemble lock mechanism and cam and install decal as per Dwg D3368.

2FFJUN 24 2015PTO

DQA:

Date:

JAN 4 2017



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed

Date:

OCT 18 2016

Work Order update only

☐

Work Order: <u>133131</u> Part No. <u>D3385-3</u> NCR No.		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☒ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐							
Date: <u>151606.02</u>		Step #: <u>120</u>		QTY Effective: <u>1</u>			MRB (QSI042) Approval <u>INS 12</u> <u>UP</u> <u>16/10/13</u>				
Description Work Order Deviation <u>Made two hinges mtrl ms 20257-c4/m129246 (batch#)</u> <u>To Fit D3368-041. To Replace D3385-3</u> <u>R.C. Toolings D3385-3 material doesn't match</u> <u>holes in assembly.</u>				Disposition <u>Acceptable</u>				Completed By <u>FF. 1500-29</u> Lead hand / Supervisor Approval Verification <u>DAS</u> <u>30</u> <u>9-89</u> <u>JUN 02 2015</u>			
Root Cause Environment ☐ No Re-verification ☐ Design ☒ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☒ Supplier ☒ Handling/Pre ☒ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☒ Misaligned/off center ☐ Turning Sequence ☐				OTHER:			

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Item ID: D3368-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tail Rotor Pedal Lock
Start Date: 5/22/15 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 5/26/15 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
110						2			

QC

Memo

0.00

Quality Control

JUN 2 5 2015

120

Identify as per dwg & Stock Location: St 492

0.00

120

Packaging

Memo

0.00

Packaging

DAS
27
9-89

JUN 2 9 2015

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

JUN 2 9 2015

JUN 2 9 2015

JUN 2 9 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Work Order ID: 133131

133131

Parent Item: D3368-041

D3368-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 5/22/15

Required Date: 5/26/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A Removed from 9 Digit 06-03-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-028 *238-028* 3/16" Dowel Pin .5" long		Purchased	No			100	Each	109.0000	2	4			
									**		FF	JUN 02 2015	
				<u>Location</u>				<u>Loc Qty</u>					
				ST568				109					
				108114				11					
				<u>M132062</u>				98		4			
385-039 *385-039* 8-32 Flat screw		Purchased	No			100	Each	96.0000	4	8			
									**		FF	JUN 02 2015	
				<u>Location</u>				<u>Loc Qty</u>					
				ST570				96					
				<u>M130688</u>				96		8			
CBL-1240 *CBI -1240* Cable		Purchased	No			100	f	101.1606	2.3333	5			
									**		FF	JUN 24 2015	
				<u>Location</u>				<u>Loc Qty</u>					
				GA				101.1606					
				<u>m130006</u>				101.1606		5			
CBL-460 *CBI -460* Loop Sleeve		Purchased	No			100	Each	322.0000	2	4			
									**		FF	JUN 24 2015	
				<u>Location</u>				<u>Loc Qty</u>					
				GA				322					
				<u>m131619</u>				322		4			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Work Order ID: 133131

Parent Item: D3368-041

Parent Item Name: Tail Rotor Pedal Lock

133131

D3368-041

Start Date: 5/22/15

Required Date: 5/26/15

Start Qty: 2.00

Required Qty: 2.00

D3368-1
D3368-1
Pedal Lock Base

Manufactured No

100

Each

3.0000

1

2

**

FF

JUN 02 2015

Location

Loc Qty

Loc Code

ST496

3

115046

3

2

D3368-3
D3368-3
Pedal Lock Cover

Manufactured No

100

Each

2.0000

1

2

**

FF

JUN 02 2015

Location

Loc Qty

Loc Code

ST497

2

119439

2

2

D3373-7
D3373-7
Cam Lock

Manufactured No

100

Each

15.0000

1

2

**

FF

JUN 02 2015

Location

Loc Qty

Loc Code

ST036

15

123528

4

94791

11

2

D3384-1
D3384-1
Cyclic Sock

Manufactured No

100

Each

1.0000

1

2

**

FF

JUN 24 2015

Location

Loc Qty

Loc Code

ST500

1

123313

1

B 133088

2

②

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Shop Packet Print

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Picklist Print

Tuesday, May 26, 2015 12:47:44 PM

Page 3

Work Order ID: 133131

133131

Parent Item: D3368-041

D3368-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 5/22/15

Required Date: 5/26/15

Start Qty: 2.00

Required Qty: 2.00

D3385-3 Manufactured No

100 Each 29.0000 1 2

D3385-3

FF JUN 02 2015

Hinge

Location

Loc Qty

Loc Code

ST036

29

117534

29

2

HX-81 Purchased No

100 Each 71.0000 1 2

HX-81

FF JUN 02 2015

1/4"-20 SHCS 3/8" long

Location

Loc Qty

Loc Code

ST554

71

123436

71

2

NAS1149F0463P Purchased No

100 Each 1,303.000 2 4

NAS1149F0463P

FF JUN 02 2015

Washer

Location

Loc Qty

Loc Code

ST260a

984

m127832

984

4

st268

319

m127832

295

m130388

24

Tuesday, May 26, 2015 12:47:44 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

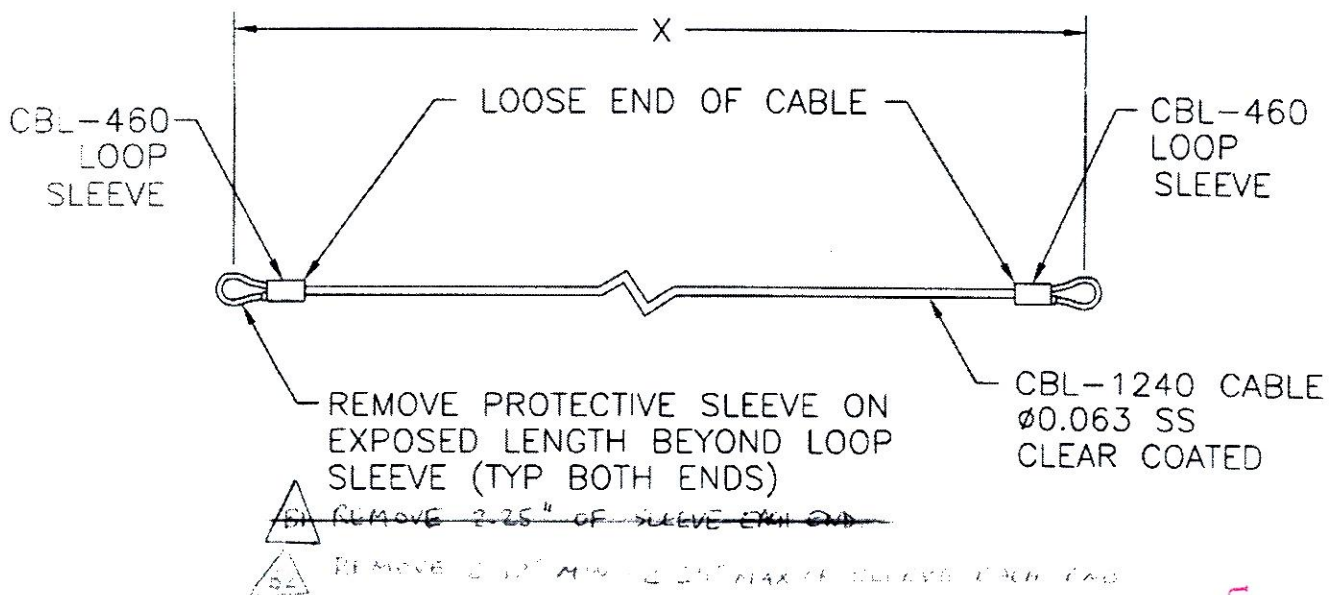
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
							Lead hand / Supervisor Approval Verification																		
							QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																							
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DESIGN <i>ME</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>ME</i>	APPROVED <i>BW</i>	DRAWING NO. D2690	REV. B SHEET 1 OF 1
DATE 97.10.02		TITLE LANYARD ASSEMBLY	SCALE NTS
A	97.07.03	NEW ISSUE	
B	97.10.02	REVISED NOTE FOR ADDITIONAL LENGTH	
B1	<i>11/01/03</i>	ADD NOTE TO REMOVE 2.25" OF SLEEVE	
B2	<i>11/01/03</i>	ADDED LENGTH	

RELEASED
971003 KE
10/10/02



D2690-X

X = LENGTH IN INCHES

NOTE: CUT CABLE 2.50* INCHES LONGER THAN 'X' LENGTH. FOLD ENDS TIGHT TO 'X' LENGTH AND CRIMP WITH SLEEVE AT END OF LOOSE END OF CABLE WITH CBL-705 CRIMPING TOOL.
*ADDITIONAL LENGTH MAY BE NECESSARY IN SOME APPLICATIONS. CUT AS REQUIRED.

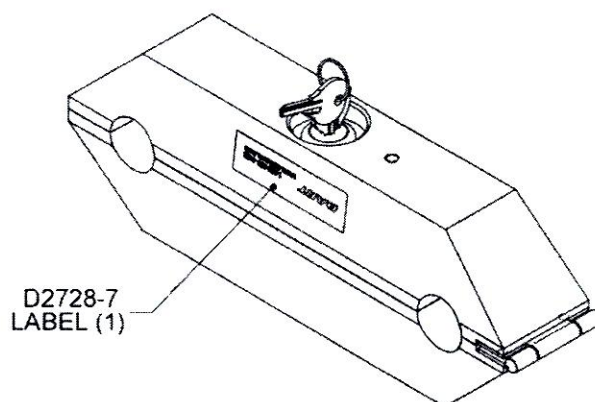
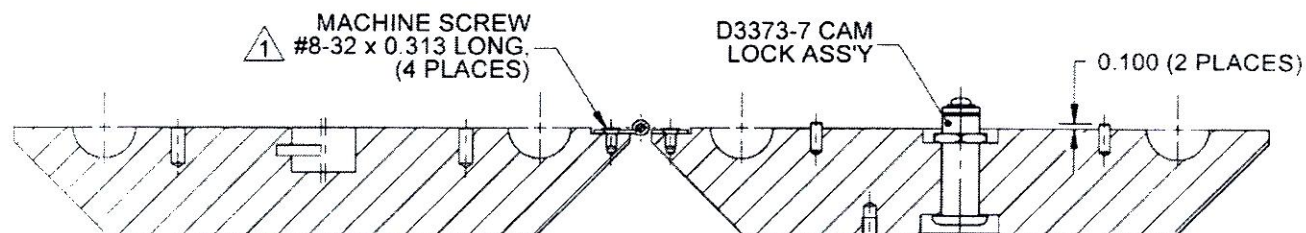
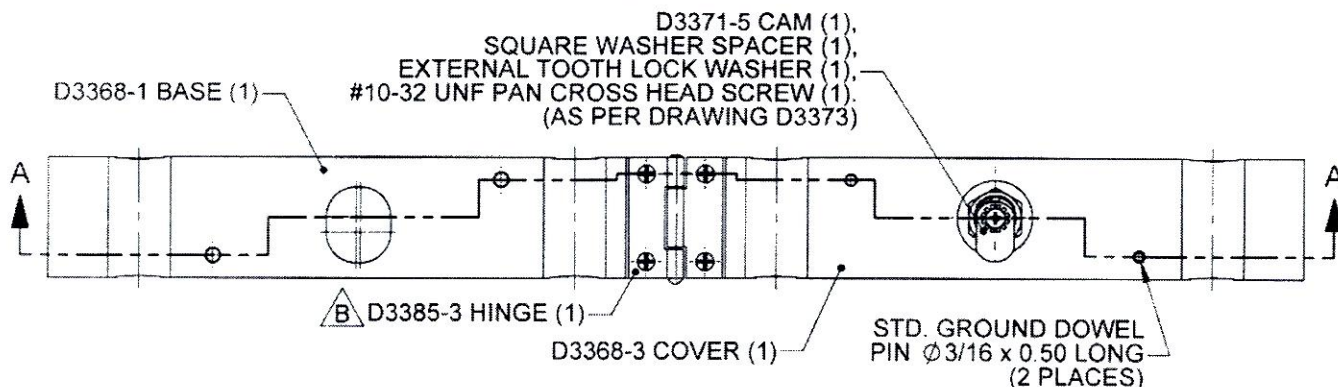
NOTE: IN SOME CASES, END HAS TO BE CRIMPED AFTER ASSEMBLY WITH ATTACHING PARTS.

SHOP COPY
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WORK ORDER
NO. 133131
MJS
150527

DEO's

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3368	REV. B SHEET 1 OF 3
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1.3
A	05.01.19	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

**PEDAL LOCK SHOWN LOCKED WITH KEY****SECTION A-A****D3368-051 PEDAL LOCK ASSEMBLY****NOTES:**

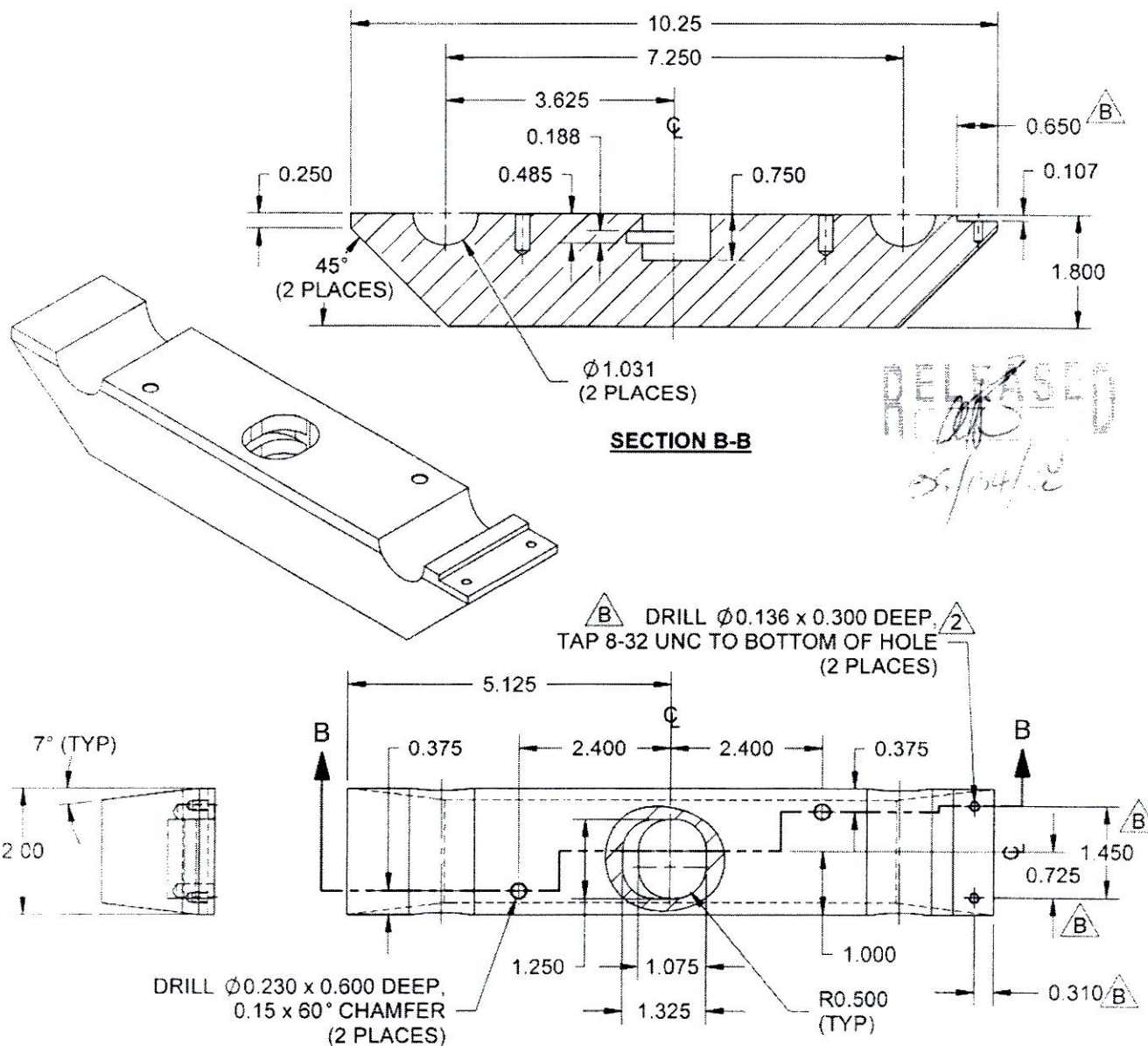
- 1) POSSIBLE SUPPLIER: SPAENAU P/N 385-044
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3368	REV. B SHEET 2 OF 3
DATE 05.03.22	TITLE PEDAL LOCK		SCALE 1:2.5

**D3368-1 BASE****NOTES:**

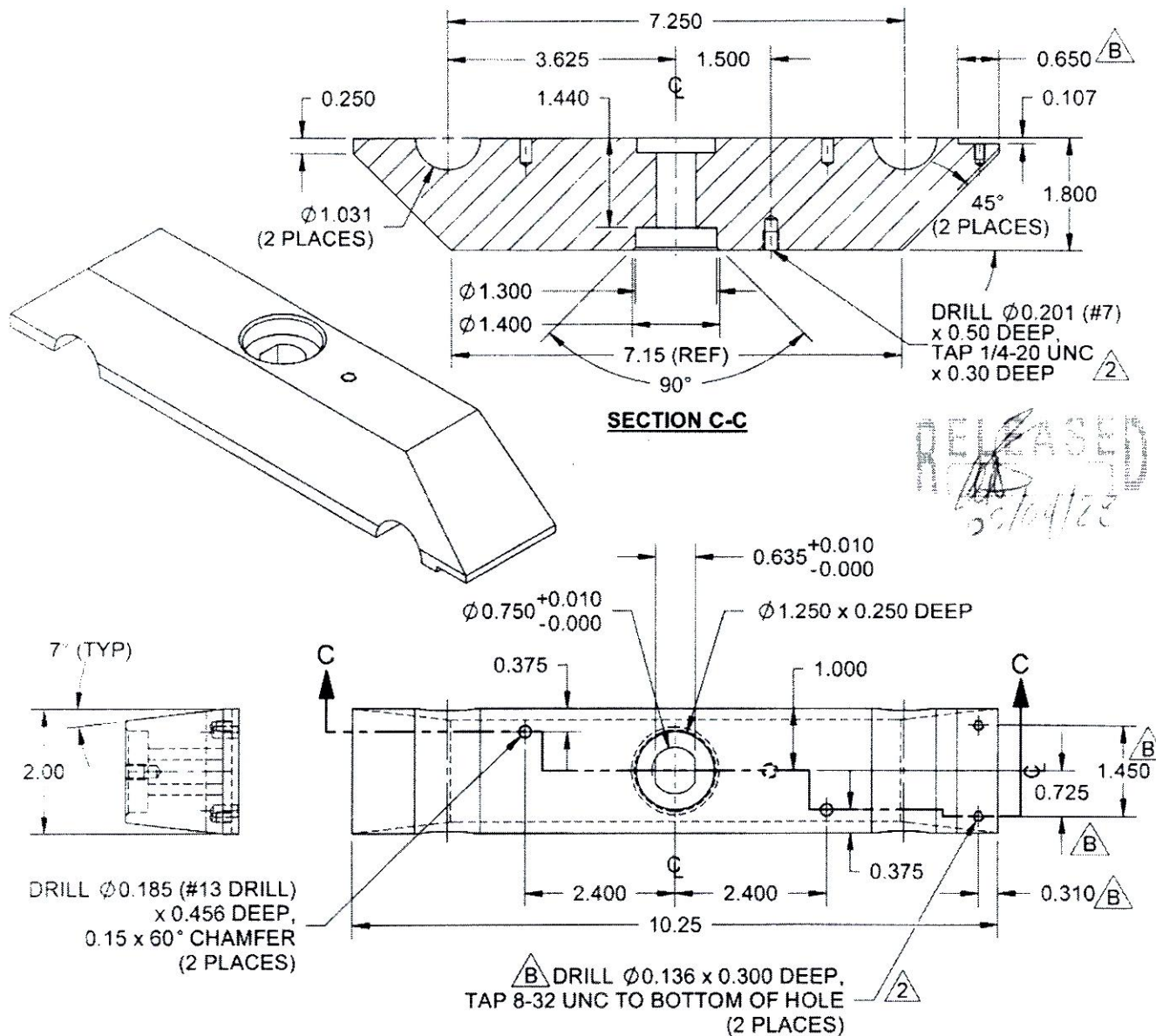
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART

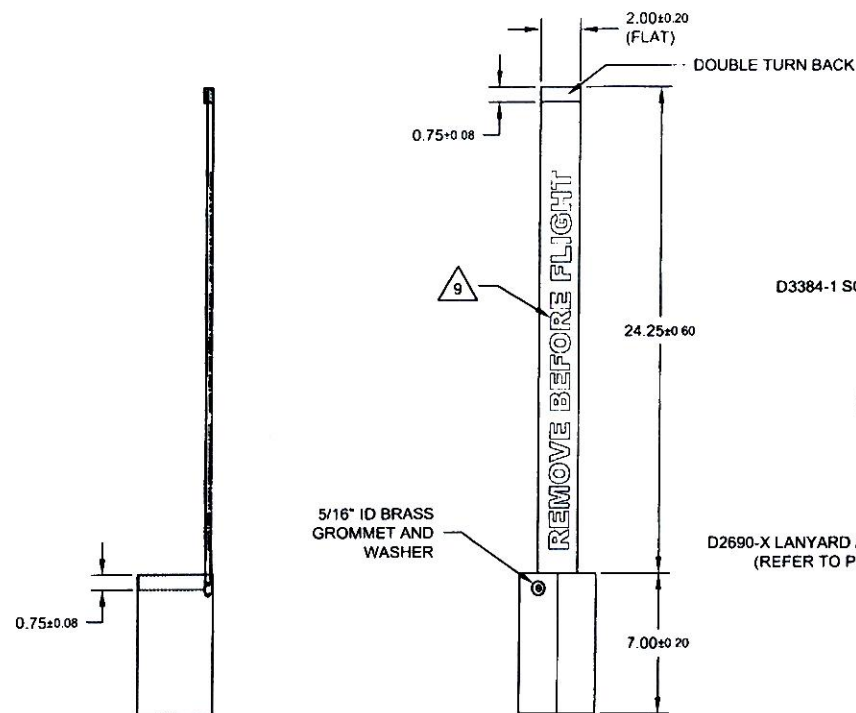
DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 11	APPROVED 11	DRAWING NO. D3368	REV. B SHEET 3 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:2.5

**D3368-3 COVER****NOTES:**

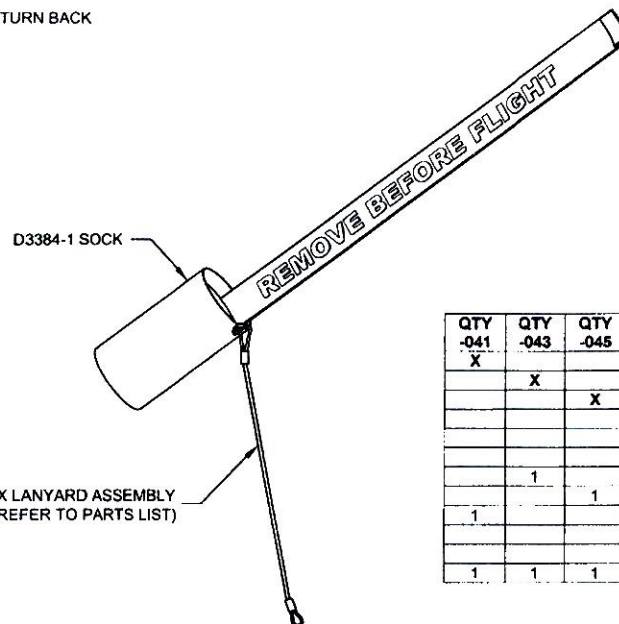
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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D3384-1 SOCK



D3384-0XX SOCK ASSEMBLY

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	P/N	DESCRIPTION
X					D3384-041	SOCK ASSEMBLY
	X				D3384-043	SOCK ASSEMBLY
		X			D3384-045	SOCK ASSEMBLY
			X		D3384-047	SOCK ASSEMBLY
				X	D3384-049	SOCK ASSEMBLY
1					D2690-8	LANYARD ASSEMBLY
		1			D2690-20	LANYARD ASSEMBLY
1					D2690-24	LANYARD ASSEMBLY
			1		D2690-28	LANYARD ASSEMBLY
				1	D2690-30	LANYARD ASSEMBLY
1	1	1	1	1	D3384-1	SOCK

D3384-1 NOTES:

- 1) SUPPLIER: TULMAR P/N 8972
- 2) MATERIAL: 420 DENIER NYLON CLOTH, PVC COATED, COLOUR RED
- 3) THREAD: STITCHING IAW D-6193 6 TO 10 STITCHES PER INCH USING V-T-295 RED NYLON THREAD, TY2, CL A, SIZE E
- 4) FINISH: NONE
- 5) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) UNITS: INCHES UNLESS OTHERWISE NOTED
- 7) BREAK SHARP EDGES: N/A
- 8) IDENTIFICATION: NONE
- 9) WEIGHT: N/A
- 9) STENCIL THE FOLLOWING: "REMOVE BEFORE FLIGHT" ON BOTH SIDES OF STRIP WITH 1" LETTERS USING WHITE INK AS PER SUPPLIER

RELEASED
2012-06-25

C	UPDATED NOTE 9. REASON: PAR12-204.	MB	12.06.25
B	CHG TOLERANCES DWG UPDATED ADD MATERIAL & SUPPLIER INFO	DC	07.11.23
A	NEW ISSUE	RF	05.01.20
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG APPR.	<i>[Signature]</i>	D3384	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SOCK ASSEMBLY	NTS
DATE	12.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMBINED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	